

Work Order ID 54319-1

December 9, 2009 11:21:17 AM

Page 1

Item ID: D3763-044

Accept

Revision ID:

Item Name: End Fitting Assembly, RH

Start Date: 07/12/2009 Start Qty: 20.00

Required Date: 21/12/2009 Req'd Qty: 20.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3763

Rev B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

Large Fab

0.00



Large Fab

Memo

0.00

1-make a 0.063" chamfer on D3763-1 fitting before ass'y □ 2-assemble and tack weld as per dwg D3763 using locating pin DT9039 □ *****lock at dwg before assembling parts (RH) ***** □ *****remove pin before welding***** □ 3-weld as per dwg D3763, QSI004 □ Alum

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

X4

CP 10/04/06

X4

CP 10/01/06

④

PD 10.01.07

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Item ID: D3763-044

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Start Date: 07/12/2009 Start Qty: 20.00

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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

=> 10/01/07



QC

Quality Control

Memo

0.00

140

Chemical Conversion Coat per QSI005 4.1

0.00

PR 10-01-7



HandFinish

Hand Finishing

Memo

0.00

150

QC3- Inspect Part Finish

0.00

11 10-01-07



QC

Quality Control

Memo

0.00

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Item ID: D3763-044

Accept



Setup Start



Revision ID:

Item Name: End Fitting Assembly, RH

Stop



Start Date: 07/12/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



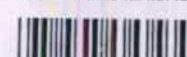
QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Packaging

Packaging

Identify as per dwg & Stock Location: 6-A

0.00

Memo

0.00

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Handwritten signature 10/01/07 (4)

10/01/07 *Handwritten signature*
ME
10-01-07

Picklist Print

December 9, 2009 11:21:21 AM

Page 1

Work Order ID: 54319

Parent Item: D3763-044

Parent Item Name: End Fitting Assembly, RH

Comments:

Start Date: 07/12/2009

Required Date: 21/12/2009

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3763-1		Manufactured	No			110	Each	42.0000	40.0000			
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End Fitting

✓

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

45891

B54364

42

42

B54364 → 8

40x

SM 10/01/09

D3763-6

Manufactured No



Tube

✓

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

40992

42735

40

8

32

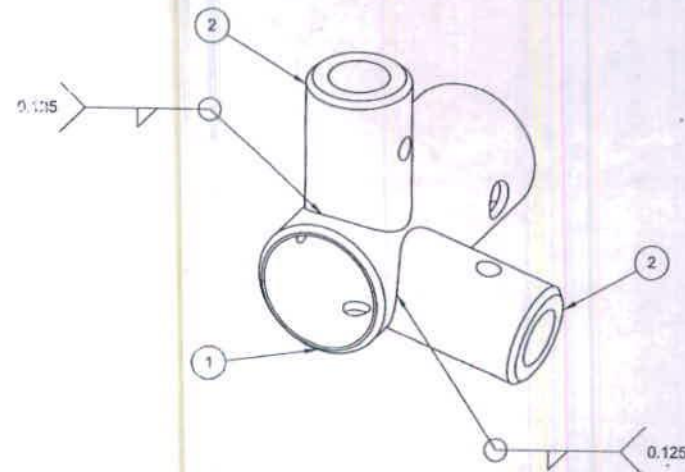
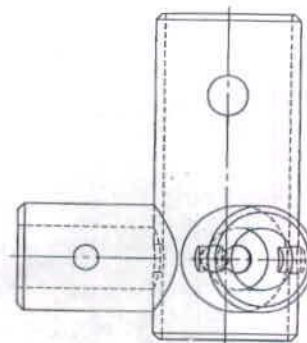
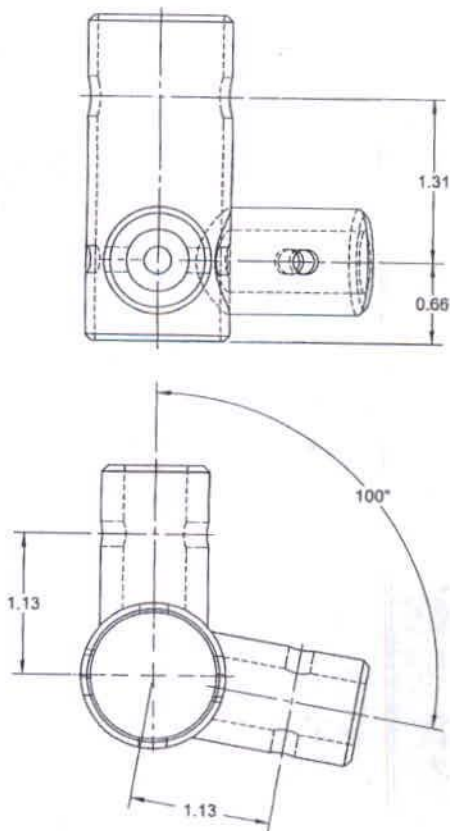
B54371

10x

8x
2x

SM 10/01/09

B54371 → 4



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3763-6	TUBE	1
2	D3763-1	FITTING	2

D3763-044 END FITTING ASSY, RH ✓

RELEASED
08-07-10

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B
DRAWN	HS		
CHECKED	PL	DRAWING NO. D3763	SHEET 3 OF 9
MFG. APPR.	PL	TITLE END FITTING	SCALE NTS
APPROVED	PL	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
DE APPR.	PL	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBINED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.06.23		

W10 54319

ES:
ATERIAL: N/A
INISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
OLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
NITS: INCHES UNLESS OTHERWISE NOTED
REAK SHARP EDGES: 0.005 TO 0.010 MAX
ENTIFICATION: N/A
EIGHT: 0.05 lbs
ELD: PER DART QSI 004

